



Dart Aerospace Ltd.
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Canada

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D4079-1**Job Sheet 193780****Part No:** D4079-1**Job Qty:** 12 pcs**Part Name:** Clamp Half, Attachment**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 4/22/19**Job Tracking No:****Due Date:** 5/15/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG REV B IPP REV: A NEW ISSUE 10*-05-10 JLM VERIFIED BY:DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	12 pcs		5/15/19	0.00	0.00	Bandsaw - 1		
110	HAAS 4 Axis - B4B	12 pcs		5/15/19	0.22	8.51	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	12 pcs		5/15/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
140	Handfinish - 1-1 Chemical-B4B	12 pcs		5/15/19	0.00	0.40	Handfinish - 1 - 1 - B4B		

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Container No: S184414



Part: D4079-1

Job No: 193780

Serial No/Batch: S184414

Revision:

Sector:

Exp Date:

Instructions: Various STC's

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Date: 05/27/19

				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	8 JUN 04 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150	Powdercoat - 4 Black Sand - B4B	12 pcs	5/15/19	0.00 0.00	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
160	QC 3	12 pcs	5/15/19	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9

170 Packaging 3-1 - Stock - B4B

12
pcs

5/15/19

0.00 0.00

QC 3 - 40

QC 3 - 19

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 -
B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 -
B4BPackaging 3 - 13 -
B4BPackaging 3 - 14 -
B4BPackaging 3 - 15 -
B4BPackaging 3 - 16 -
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B4BPackaging 3 - 19 -
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B4BPackaging 3 - 26 -
B4BPackaging 3 - 27 -
B4BPackaging 3 - 28 -
B4BPackaging 3 - 29 -
B4BPackaging 3 - 30 -
B4BPackaging 3 - 31 -
B4BPackaging 3 - 32 -
B4BPackaging 3 - 33 -
B4BPackaging 3 - 34 -
B4BPackaging 3 - 35 -
B4BPackaging 3 - 36 -
B4B

180 QC 21 - SA

12
pcs

5/15/19

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 53

DAG
21

JUN 06 2019

Part Op 100 - (Bandsaw) Cut blank 2.750" long
 Descriptions: 110 - (HAAS CNC Vertical Machine) Mill as per Dwg and Folio FA931 Dwg Rev: _____
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3)
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.000X02.000	6061-T6 Bar 2.00 X 2.00	2.7600 ft (.23 ea)	100-Bandsaw - 1	515 24 15

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B2.000X02.000	3	12	0

MAT
used
2.800'

Scrap
0.229'

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp Half, Attachment	2.502Inches $\pm$ 0.010	2.512 2.492		
2	Clamp Half, Attachment	0.203Inches $\pm$ 0.005 - 0.001	0.208 0.202	Diameter	
3	Clamp Half, Attachment	0.750Inches $\pm$ 0.030	0.780 0.720		
4	Clamp Half, Attachment	0.375Inches $\pm$ 0.010	0.385 0.365		
5	Clamp Half, Attachment	0.310Inches $\pm$ 0.010	0.320 0.300		
6	Clamp Half, Attachment	1.882Inches $\pm$ 0.010	1.892 1.872		
7	Clamp Half, Attachment	0.780Inches $\pm$ 0.030	0.810 0.750		
8	Clamp Half, Attachment	0.130Inches $\pm$ 0.030	0.160 0.100	Radius	
9	Clamp Half, Attachment	1.440Inches $\pm$ 0.010	1.450 1.430		
10	Clamp Half, Attachment	0.380Inches $\pm$ 0.010 - 0.000	0.390 0.380	Radius	
11	Clamp Half, Attachment	0.050Inches $\pm$ 0.010	0.060 0.040	Radius	
12	Clamp Half, Attachment	0.730Inches $\pm$ 0.010	0.740 0.720	Radius	
13	Clamp Half, Attachment	0.257Inches $\pm$ 0.030	0.287 0.227	Diameter	
14	Clamp Half, Attachment	0.250Inches $\pm$ 0.006 - 0.001	0.256 0.249	Radius	
15	Clamp Half, Attachment	0.390Inches $\pm$ 0.030	0.420 0.360		
16	Clamp Half, Attachment	0.850Inches $\pm$ 0.010	0.860 0.840		
17	Clamp Half, Attachment	0.025Inches $\pm$ 0.010	0.035 0.015		
18	Clamp Half, Attachment	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle	
19	Clamp Half, Attachment	0.100Inches $\pm$ 0.010	0.110 0.090		
20	Clamp Half, Attachment	0.050Inches $\pm$ 0.030	0.080 0.020	Radius	
21	Clamp Half, Attachment	1.240Inches $\pm$ 0.010	1.250 1.230		
22	Clamp Half, Attachment	1.650Inches $\pm$ 0.030	1.680 1.620		
23	Clamp Half, Attachment	0.600Inches $\pm$ 0.030	0.630 0.570		
24	Clamp Half, Attachment	0.230Inches $\pm$ 0.030	0.260 0.200		
25	Clamp Half, Attachment	0.025Inches $\pm$ 0.010	0.035 0.015		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

